

018372



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D2360**Job Sheet 213681****Part No:** D2360**Job Qty:** 6 pcs**Part Name:** Litter Tie Down Bracket**Part Weight:** 0 lbs**Status:** New**Priority:** Medium**Job Created:** 10/1/20**Job Tracking No:****Due Date:** 11/30/20**Created By:** Marie Lajeunesse**Type:** Stock**Description:****Note:** DWG D2341 REV G, D2360 REV D IPP rev H 07.06.12 ecn 825 EC**Ship Via:****Bill of Materials****Job Routing**

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Lead Time	Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier			
100	Bandsaw - 1	6 pcs	11/27/20		0.00	0.20	Bandsaw - 1			DAS 33 9-89 20/10/21
110	HAAS 4 Axis - B4B	6 pcs	11/28/20		0.26	8.96	HAAS - 1 - B4B			
							HAAS - 2 - B4B			DAS
							HAAS - 3 - B4B			33 20/10/21
							HAAS - 4 - B4B			9-89
120	QC 2	6 pcs	11/28/20		0.00	0.00	QC 2 - 1			
							QC 2 - 12			
							QC 2 - 14			
							QC 2 - 17			
							QC 2 - 19			
							QC 2 - 2			
							QC 2 - 20			
							QC 2 - 22			
							QC 2 - 23			
							QC 2 - 25			
							QC 2 - 32			
							QC 2 - 33			DAS 33 20/10/21
							QC 2 - 35			9-89
							QC 2 - 39			
							QC 2 - 4			
							QC 2 - 40			
							QC 2 - 44			
							QC 2 - 45			
							QC 2 - 48			
							QC 2 - 49			
							QC 2 - 50			
							QC 2 - 51			
							QC 2 - 52			
							QC 2 - 57			
							QC 2 - 62			



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Container No: S307453**Part:** D2360**Job No:** 213681**Serial No/Batch:** S307453**Inspector:****Exn Date:****Instructions:** Var STC's

				QC 2 - 63					
				QC 2 - 8					
				QC 2 - 66					
				QC 2 - 64					
				QC 2 - 65					
				QC 2 - 5					
				QC 2 - 71					
				QC 2 - 73					
				QC 2 - 69					
				QC 2 - 76					
				QC 2 - 86					
				QC 2 - 83					
				130 QC 8	6 pcs	11/28/20	0.00 0.00	QC 8 - 12	
QC 8 - 14									
QC 8 - 17									
QC 8 - 20									
QC 8 - 25									
QC 8 - 3									
QC 8 - 32	J.C.L. 20-10-22								
QC 8 - 33									
QC 8 - 35									
QC 8 - 39									
QC 8 - 4									
QC 8 - 44									
QC 8 - 45									
QC 8 - 49									
QC 8 - 58									
QC 8 - 8									
QC 8 - 9									
QC 8 - 68									
QC 8 - 67									
QC 8 - 1 (A)									
QC 8 - 47									
QC 8 - 40									
QC 8 - 52									
QC 8 - 23									
QC 8 - 57									
QC 8 - 76									
QC 8 - 61									
QC 8 - 66									
QC 8 - 73									
QC 8 - 82									
140 Handfinish - 1-1 Chemical-B4B	6 pcs	11/28/20	0.00 0.47					Handfinish - 1 - 1 - B4B	
								Handfinish - 1 - 2 - B4B	
								Handfinish - 1 - 3 - B4B	
								Handfinish - 1 - 4 - B4B	
								Handfinish - 1 - 5 - B4B	
								Handfinish - 1 - 6 - B4B	
								Handfinish - 1 - 7 - B4B	
								Handfinish - 1 - 8 - B4B	
				Handfinish - 1 - 9 - B4B					
				Handfinish - 1 - 10 - B4B					
				Handfinish - 1 - 11 - B4B					
				Handfinish - 1 - 12 - B4B					
				Handfinish - 1 - 13 - B4B					
				Handfinish - 1 - 14 - B4B					
				Handfinish - 1 - 15 - B4B					
				Handfinish - 1 - 16 - B4B					
				Handfinish - 1 - 17 - B4B					
								Plex 10/1/20 12:43 PM Dart.lajeunesse.marie	

150 Powdercoat - 1 White Gl(A)- B4B	6 pcs	11/28/20	0.00 0.30	Handfinish - 1 - 18 - B4B	
				Handfinish - 1 - 19 - B4B	
				Handfinish - 1 - 20 - B4B	
				Handfinish - 1 - 21 - B4B	DAS
				Handfinish - 1 - 22 - B4B	47 NOV 13 2020
				Powdercoat - 1 - B4B	9-89
				Powdercoat - 2 - B4B	
				Powdercoat - 3 - B4B	
				Powdercoat - 4 - B4B	
				Powdercoat - 5 - B4B	
				Powdercoat - 6 - B4B	
160 QC 3	6 pcs	11/28/20	0.00 0.00	Powdercoat - 7 - B4B	
				Powdercoat - 8 - B4B	
				Powdercoat - 9 - B4B	
				Powdercoat - 10 - B4B	
				QC 3 - 10	
				QC 3 - 13	
				QC 3 - 15	
				QC 3 - 17	
				QC 3 - 18	
				QC 3 - 2	
				QC 3 - 28	
170 Small Fab - 2 - B4B	6 pcs	11/30/20	0.00 1.89	QC 3 - 3	
				QC 3 - 30	
				QC 3 - 34	
				QC 3 - 36	
				QC 3 - 41	
				QC 3 - 51	
				QC 3 - 58	DAS
				QC 3 - 59	58 NOV 27 2020
				QC 3 - 68	9-89
				QC 3 - 9	
				QC 3 - 40	
180 QC 5	6 pcs	11/30/20	0.00 0.00	QC 3 - 19	
				QC 3 - 43	
				QC 3 - 24	
				QC 3 - 61	
				QC 3 - 81	
				QC 3 - 82	
				QC 3 - 87	
				QC 3 - 47	DAS
				Small Fab - 1 - B4B	58 NOV 27 2020
				Small Fab - 2 - B4B	9-89
				Small Fab - 3 - B4B	
Small Fab - 4 - B4B					
Small Fab - 5 - B4B					
Small Fab - 6 - B4B					
Small Fab - 7 - B4B					
Small Fab - 8 - B4B					
Small Fab - 9 - B4B					
Small Fab - Various 1 - B4B					
QC 5 - 10					
QC 5 - 12					
QC 5 - 17					
QC 5 - 18					
QC 5 - 19					
QC 5 - 22					
QC 5 - 24					

M25-1469

START: 8:15.

CLT 300°

FINISH: 8:45.

20-11-16

DAS 34 9-89

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				QC 5 - 3	
				QC 5 - 43	
				QC 5 - 49	
				QC 5 - 51	
				QC 5 - 58	
				QC 5 - 68	
				QC 5 - 9	
				QC 5 - 50	
				QC 5 - 30	
				QC 5 - 40	NOV 30 2020
				QC 5 - 61	9-89
				QC 5 - 81	
				QC 5 - 82	
190	Packaging 3-1 - Stock - B4B	6	11/30/20	0.00 0.00	Packaging 3 - 1 - B4B
	pcs				Packaging 3 - 2 - B4B
					Packaging 3 - 3 - B4B
					Packaging 3 - 4 - B4B
					Packaging 3 - 5 - B4B
					Packaging 3 - 6 - B4B
					Packaging 3 - 7 - B4B
					Packaging 3 - 8 - B4B
					Packaging 3 - 9 - B4B
					Packaging 3 - 10 - B4B
					Packaging 3 - 11 - B4B
					Packaging 3 - 12 - B4B
					Packaging 3 - 13 - B4B
					Packaging 3 - 14 - B4B
					Packaging 3 - 15 - B4B
					Packaging 3 - 16 - B4B
					Packaging 3 - 17 - B4B
					Packaging 3 - 18 - B4B
					Packaging 3 - 19 - B4B
					Packaging 3 - 20 - B4B
					Packaging 3 - 21 - B4B
					Packaging 3 - 22 - B4B
					Packaging 3 - 23 - B4B
					Packaging 3 - 24 - B4B
					Packaging 3 - 25 - B4B
					Packaging 3 - 26 - B4B
					Packaging 3 - 27 - B4B
					Packaging 3 - 28 - B4B
					Packaging 3 - 29 - B4B
					Packaging 3 - 30 - B4B
					Packaging 3 - 31 - B4B
					Packaging 3 - 32 - B4B
					Packaging 3 - 33 - B4B
					Packaging 3 - 34 - B4B
					Packaging 3 - 35 - B4B
					Packaging 3 - 36 - B4B
					Packaging 3 - 37 - B4B
200	QC 21 - SA	6	11/30/20	0.00 0.00	QC 21 - SA - 21
	pcs				QC 21 - SA - 70
					QC 21 - SA - 9
					QC 21 - SA - 77
					QC 21 - SA - 28

Part Op 100 - (Bandsaw) Cut blanks: 12.65" Long
 Descriptions: 110 - (HAAS CNC vertical machine #1) 1-Machine as per Folio D2341 and Dwg D2341 2-Deburr
 120 - (QC2- Inspect parts off machine FAI/FAIB)
 130 - (QC8- Inspect parts - second check)
 140 - (Chemical Conversion Coat per QSI005 4.1)

150 - (White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum) START TIME: _____ OVEN TEMPERATURE: _____

FINISH TIME: _____

160 - (QC3- Inspect Part Finish)

170 - (Small Fab) Assemble as per dwg D2360

180 - (QC5- Inspect part completeness to step on W/O)

190 - (Identify as per dwg & Stock Location: _____)

200 - (QC21- Final Inspection - Work Order Release)

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D6201	T Extrusion	6.3240 ft (1.054 ea)	100-Bandsaw - 1	S295825
AN526C1032R18	Screw <i>326</i>	6 Ea (1 ea)	170-Small Fab - 2 - B4B	S305783
D2002-015	Knob <i>GA18</i>	12 pcs (2 ea)	170-Small Fab - 2 - B4B	S312496X8
D2345	Lock Channel <i>11</i>	6 pcs (1 ea)	170-Small Fab - 2 - B4B	S229120
D2366	Lock Handle <i>ST006</i>	12 pcs (2 ea)	170-Small Fab - 2 - B4B	S229120 Y7 S3
D2367	Handle Knob <i>11</i>	6 pcs (1 ea)	170-Small Fab - 2 - B4B	S229120 Y7 S3
D2372	Quick Release <i>GA117</i>	12 pcs (2 ea) <i>S316634</i>	170-Small Fab - 2 - B4B	S229120 Y7 S3
D2373	Spring <i>GA128</i>	6 pcs (1 ea)	170-Small Fab - 2 - B4B	S229120 Y7 S3
D2444	Pip Pin Assembly <i>GA127</i>	6 pcs (1 ea)	170-Small Fab - 2 - B4B	S229120 Y7 S3
MS20470AD3-4 <i>43</i>	Rivet, Universal Head <i>GA127</i>	6 Ea (1 ea)	170-Small Fab - 2 - B4B	S229120 Y7 S3
MS21042L3	Nut <i>305</i>	18 Ea (3 ea)	170-Small Fab - 2 - B4B	S229120 Y7 S3
MS27039-1-13	Screw <i>280</i>	6 Ea (1 ea)	170-Small Fab - 2 - B4B	S229120 Y7 S3
MS27039-1-15	Screw <i>GA117</i>	12 Ea (2 ea)	170-Small Fab - 2 - B4B	S229120 Y7 S3
NAS1149D0332J	Washer <i>ST264</i>	48 Ea (8 ea)	170-Small Fab - 2 - B4B	S229120 Y7 S3
NAS1149D0363J	Washer <i>ST264</i>	12 Ea (2 ea)	170-Small Fab - 2 - B4B	S229120 Y7 S3
NAS679A3W	Nut <i>GA020</i>	6 Ea (1 ea)	170-Small Fab - 2 - B4B	S229120 Y7 S3

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Bandsaw - 1	D6201	6	20	0
170-Small Fab - 2 - B4B	AN526C1032R18	6	7	0
	D2002-015	12	3	0
	D2345	6	10	0
	D2366	12	7	0
	D2367	6	12	0
	D2372	12	9	0
	D2373	6	14	0
	D2444	6	9	0
	MS20470AD3-4	6	4,260	0
	MS21042L3	18	1,014	0
	MS27039-1-13	6	108	0
	MS27039-1-15	12	87	0
	NAS1149D0332J	48	869	0
	NAS1149D0363J	12	447	0
	NAS679A3W	6	180	0

Part Specifications

Specifications could not be found.

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DART AEROSPACE LTD		Work Order: 213681
Description: Litter Tie Down Bracket (Locking)		Part Number: D2341
Inspection Dwg: D2341	Rev: G	Page 1 of 1

INSPECTION SHEET

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
1.750	+/-0.010	1,749	✓		MJP-04	vern
2.75	+/-0.030	2,750	✓		↓	↓
Ø0.246	+0.005/-0.001	0,246	✓		↓	↓
Ø0.191	+0.005/-0.001	0,191	✓		↓	↓
R0.25	+/-0.030	0,250	✓		---	radius gauge
R0.40	+/-0.030	0,400	✓		---	---
12.50	+/-0.030	12,500	✓		31006	height gauge
11.750	+/-0.010	11,750	✓		↓	↓
11.00	+/-0.030	11,000	✓		↓	↓
7.00	+/-0.030	7,000	✓		↓	↓
6.250	+/-0.010	6,250	✓		↓	↓
5.50	+/-0.030	5,500	✓		MJP-04	vern
1.50	+/-0.030	1,500	✓		↓	↓
0.750	+/-0.010	0,750	✓		↓	↓
0.400	+/-0.010	0,402	✓		↓	↓
1.584	+/-0.010	1,580	✓		↓	↓
2.610	+/-0.010	2,606	✓		↓	↓
0.250	+/-0.010	0,249	✓		↓	↓
0.844	+/-0.010	0,843	✓		↓	↓
Ø0.250	+/-0.010	0,249	✓		↓	↓
0.750	+/-0.010	0,749	✓		↓	↓
3.313	+/-0.010	3,312	✓		↓	↓
4.250	+/-0.010	4,246	✓		↓	↓
1.250	+/-0.010	1,247	✓		↓	↓

Measured by: DAS 33	Checked by: J.C.L.	QC Inspector:
Date: 9-89 25/10/20	Date: 20-10-22	Date:

Engineering Approval: (if necessary)	Date:
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Rev	Date	Change	Revised by	Approved
A	06.05.24	New Issue P/O D2360	KJ/JLM	
B	07.07.17	Dwg Rev. updated	KJ/JLM	
C	10.02.02	Dimensions updated	KJ	
D	16.06.14	Dimensions updated per Dwg Rev G	KJ	

Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date :	Sequence #:	QTY Affected :		MRB (QSI042)	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor	
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details:					